



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-698-023
Job Sheet 182667



Part No: D412-698-023

Job Qty: 4 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/29/18

Job Tracking No:

Due Date: 9/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time		
90	Start up Operation	4 Ea	9/26/18	9/26/18	0.00	0.00	Start Up Stores/Pkg-2		6	SEP 17 2018
110	Packaging	4 pcs	9/26/18	9/26/18	0.00	0.00	Packaging1-4		9-89	
120	QC	4 pcs	9/26/18	9/26/18	0.00	0.00	QC4		BB	SRB
130	Packaging	4 pcs	9/26/18	9/26/18	0.00	0.00	Packaging3-2		BB	SRB
135	DC	4 pcs	9/26/18	9/26/18	0.00	0.00	DC		21	SEP 21 2018
140	QC21-FG	4 Ea	9/26/18	9/26/18	0.00	0.00	QC21		9-89	

Part Op
Descriptions: 135 - Photocopy bluefile & type labels per PPP D412-698-023 CHG003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop	4 Ea (1 ea)	90-Start up Operation	5099359
D3594-043	Floor Doubler Assembly, LH	4 Ea (1 ea)	90-Start up Operation	5081372x5 5108095 x1
D3594-044	Floor Doubler Assembly, RH	4 Ea (1 ea)	90-Start up Operation	5108110x2 5107594x4
D3594-5	Doubler	4 Ea (1 ea)	90-Start up Operation	508268
D3622-1	Ball Stud	8 Ea (2 ea)	90-Start up Operation	5080667x7 5x 5112678
MS20426AD4-4	Rivet	8 Ea (2 ea)	90-Start up Operation	5125445x4
MS21073L5	Anchor Nut	4 Ea (1 ea)	90-Start up Operation	5093550
NAS1149D0516J	Washer	8 Ea (2 ea)	90-Start up Operation	5007015

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-11	4	8	0
	D3594-043	4	7	0
	D3594-044	4	1	0
	D3594-5	4	4	0
	D3622-1	8	7	0
	MS20426AD4-4	8	310	0
	MS21073L5	4	26	0
	NAS1149D0516J	8	112	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		QTY Effective :		MRB (QSI042) Approval			
Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Container No: S110440 Part: D412 - 698 - 023 Job No: 182667 Serial No/Batch: S110440 Revision: G Inspector: _____ Exp Date: _____ Instructions: TC STC SH92 - 43 Issue 5, FAA STC SRD1446NY 08/02/08, EASA S		FAULT CATEGORY					
Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence					
		OTHER :					

Specifications could not be found.

Plex 8/29/18 2:36 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

Change Record

PAGE 1 OF 1

Part Number: D412-698-023

Description: AUTOMATIC DOOR OPENER INSTALLATION

[illegible]